

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016402**Date Inspected:** 23-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). PP13 ABF-SUB-001503R00 (Westbound)
- 2). OBG Field Splice 3W/4W Weld ID: F1, Face A
- 3). OBG Field Splice 4W/5W Weld ID: E1 & E2, Face B
- 4). OBG Field Splice 5W/6W Weld ID: C2, Face A
- 5). OBG Field Splice 5W/6W Weld ID: E1 & E2, Face A
- 6). Welder Qualification Testing in progress.

The QAI periodically observed the QA Verification status board located in the QC Conex and no QA verification became available on this date during the QA Inspector's shift.

- 1). PP13 ABF-SUB-001503R00 (Westbound)

The QAI observed that welding is complete at this location and the QAI periodically observed AB/F approved welder Kenneth Chappell (ID 3833) performing grinding to remove the weld reinforcement of the horizontal and vertical Complete Joint Penetration (CJP) welds. The QAI observed that the flush grinding was complete and appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 3W/4W Weld ID: F1 Face A

The QAI periodically observed AB/F personnel performing grinding of the A face of Weld ID: F1 to excavate (2)

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two Repair Cycle 3 (R-3) Ultrasonic Testing (UT) repairs. The QAI observed QC Inspector Tom Pasqualone performing Magnetic Particle Testing (MT) of the excavated areas prior to repair welding. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. The QAI then periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing repair welding per the (SMAW) process in the 3G (vertical) position. See photo below. QC Inspector Tom Pasqualone was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1000-Repair. The QAI observed the completion of welding at this location and observed that the work appeared to be in general compliance with contract documents.

3). OBG Field Splice 4W/5W Weld ID: E1 & E2, Face B

The QAI periodically observed ABF personnel performing Plasma Cutting and grinding to prepare a groove for back welding. The work at this location was in process for the remainder of the QA Inspectors shift.

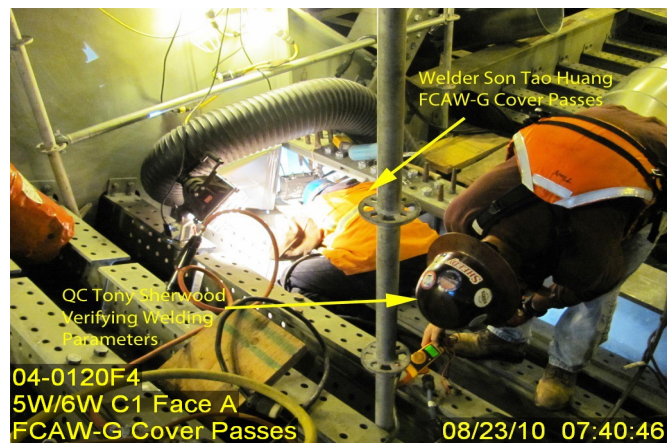
4). OBG Field Splice 5W/6W Weld ID: C2, Face A

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) performing welding per the Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position of cover passes on the last 600mm of weld ID: C2. See photo below. The QAI observed QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the approved Welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3042B-1. The QAI observed that the work at this location was complete and appeared to be in general compliance with contract documents.

5). OBG Field Splice 5W/6W Weld ID: E1 & E2, Face A

The QAI periodically observed AB/F approved welders Song Tao Huang (ID 3794) and Jin Quan Huang (ID 9340) setting up to perform FCAW-G at OBG Field Splice 5W/6W Weld ID: E1 & E2 from Face A.

6). The QAI periodically observed that AB/F approved welder Jin Pei Wang was performing qualification testing per the SMAW process in the (3G & 4G) positions. The QAI periodically observed that QC Inspector Mike Johnson periodically observed Mr. Wang. See Summary of Conversations below.



Summary of Conversations:

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From Item 6).

The QAI approached QC Inspector Mr. Mike Johnson and inquired if welder Wang was taking welder qualification tests. Mr. Johnson stated that he was testing in the 3G and 4G positions and went on to say that QA does not normally monitor welder qualification testing on the project. The QAI replied that he did not intend to monitor the testing. Mr. Johnson also said that he had removed a grinder from Mr. Wang to ensure that he did not use it during the test.

Other conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

Inspected By:	Madison,Bert	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
